

The back-up flange in Fig. 5 can be made of carbon steel, ductile iron, or stainless steel. The back-up flange can be furnished in 150# rating or 300# rating depending on the pressure requirements of the piping system. The back up flange has a chamfer on the front of the opening (6) to facilitate an intimate fit backing up the stub end (Fig. 6)

Assembly of the threaded socket stub end system involves cutting and preparing the pipe and plastic liner, and threading the end of the steel pipe per the manufacturer's field flare instructions for the type of plastic lined pipe being fabricated. The back-up flange is placed over the end of the pipe, the threaded stub end threaded onto the pipe housing, and the back-up flange is moved up behind the stub end. The extending plastic liner is heat flared over the face forming the gasket for the pipe in accordance with the plastic lined pipe manufacturer's instructions.

CLAIM OR CLAIMS

What I claim as my invention is:

A pipe segment comprising:

a pipe having a pair of ends;

a rotating back up flange is placed over an end of said pipe;

a socket stub end placed on the said end of said pipe and affixed to said pipe;

a liner, received within said pipe, having a liner flare extending radially outward and positioned in overlapping relation with said socket stub end face forming a gasket; and

said socket stub end having at least one predetermined vent hole having an inlet opening located behind said socket and an outlet opening located behind said stub end, whereby permeated gases trapped between said pipe and said liner can be vented through at least one defined vent hole.